

Work Order ID 77829

December-21-11 3:42:47 PM

77829

Page 1

Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 21/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3319	Rev B

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 B12-1-4
 FLOW CNC Waterjet 1-Cut as per Dwg D3319 Dwg Rev: B Prog Rev: B 2-
 1010 1048 Debur if necessary 8

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 B12-1-4
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 5 12/01/05
 Quality Control 48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3319-3

Accept

N900040100

Setup Start

NS1

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Stop

NS2

Item Name: Wearplate

Start Date: 21/12/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 8.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

N/A

140

140

Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: B

SB 12/01/09

8

150

150

QC

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

SB 12/01/09

8

Quality Control

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Large Fab	0.00				(8)			
	Memo	0.00							
	Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:								
	Qty Part Number Description Batch A/R								
	N/A 7560 Hardcoat Rod M119712								
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
	Quality Control								
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00				(18)			
	Quality Control								

W/O:		WORK ORDER CHANGES					
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Required Date: 05/01/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
190									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 12:40								
	FINISH TIME: 32:00								
	OVEN TEMPERATURE: 170								
200	QC3- Inspect Part Finish	0.00							
200									
QC		0.00							
Quality Control	Memo								
210	Packaging	0.00							
210									
Packaging		0.00							
Packaging									
	Memo								
	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-3, B/N: BXXXXXFor Product Eligibility see PDA05-18and StockLocation: 497								

8x 8 m / 12/01/24

8x 6 m / 12/01/24
COUNTED & MEASURED

12/12/2011 (80)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 77829***77829***

Page 5

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Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/11/30
PL 12-01-27
(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-21-11 3:42:50 PM

Page 1

Work Order ID: 77829

77829

Parent Item: D3319-3

D3319-3

Parent Item Name: Wearplate

Start Date: 21/12/2011

Required Date: 05/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: A05.05.12New issueKJ/JLM

IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	251.3000	3.2524	27.38863			

M1010S18GA

1010/1025 SHEET .048

**

B12-1-4

Location

Loc Qty

Loc Code

MAT019

251.3

116268

21.5

117806

229.8

117806

117806

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77 829
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	✓		T B01	
74.420	+/-0.010	74.420	✓		T	
62.770	+/-0.010	62.770	✓		T	
52.890	+/-0.010	52.890	✓		T	
30.790	+/-0.010	30.790	✓		T	
8.690	+/-0.010	8.690	✓		T	
0.60	+/-0.030	0.603	✓		V B02	
2.690	+/-0.010	2.691	✓		V	
2.940	+/-0.010	2.936	✓		V	
3.527	+/-0.010	3.527	✓		V	
4.518	+/-0.010	4.517	✓		V	
Ø0.190	+0.005/-0.001	0.191	✓		V	
2.940	+/-0.010	2.949	✓		V	
2.940	+/-0.010	2.949	✓		V	
2.690	+/-0.010	2.699	✓		V	
5.063	+/-0.010	5.064	✓		V	
6.163	+/-0.010	6.169	✓		V	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	0.315 x 0.611	✓		V	
0.048	+/-0.010	0.044	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-1-14	Date: 12/01/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

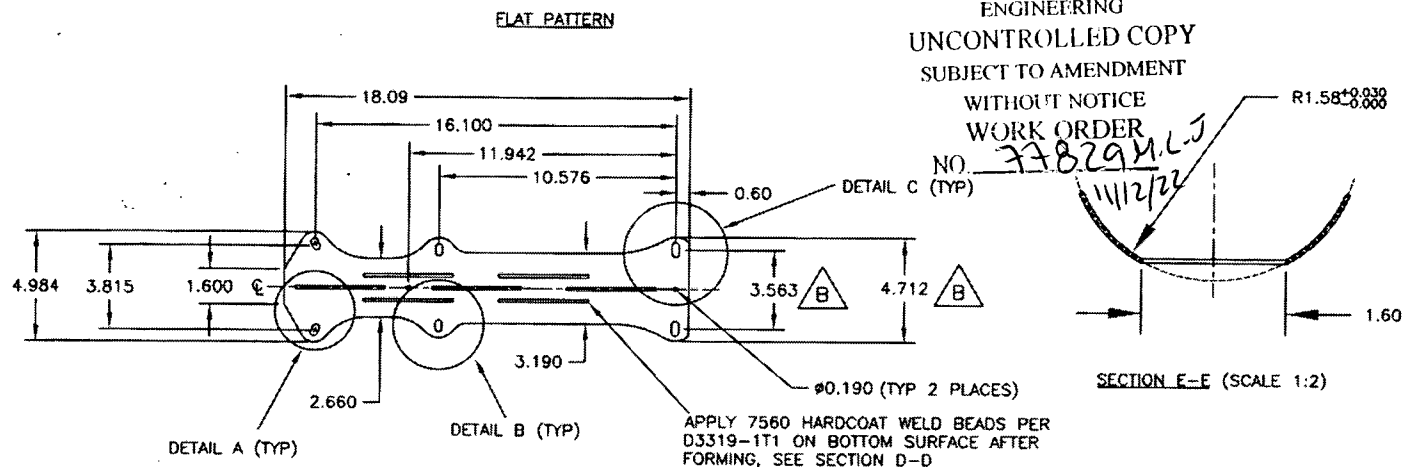
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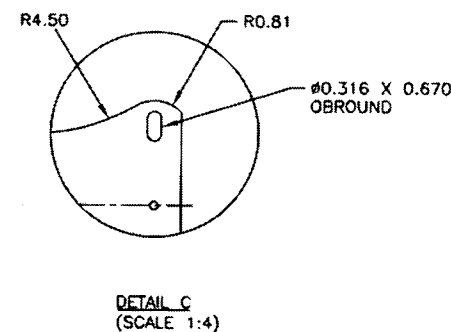
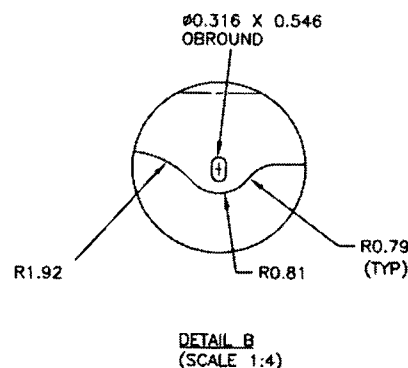
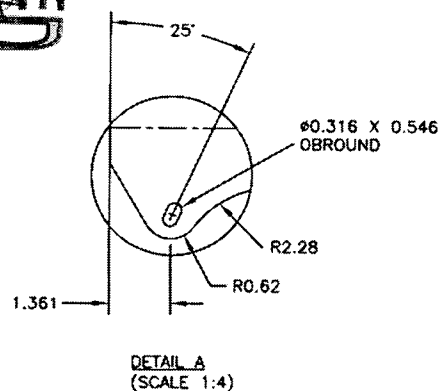
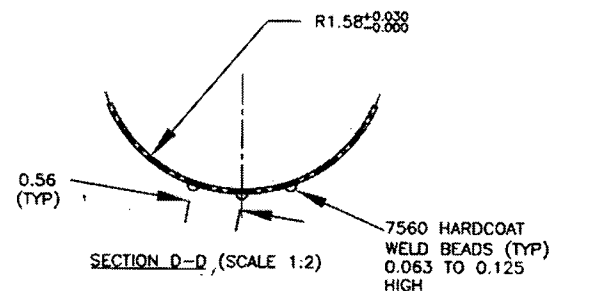
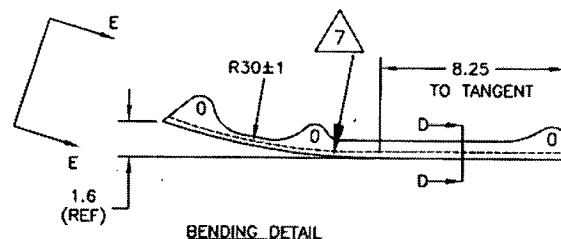
NOTE: Date & initial all entries

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 778294.1.5
11/12/22



RELEASED
05-09-20



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
REV.	DATE	DESCRIPTION
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

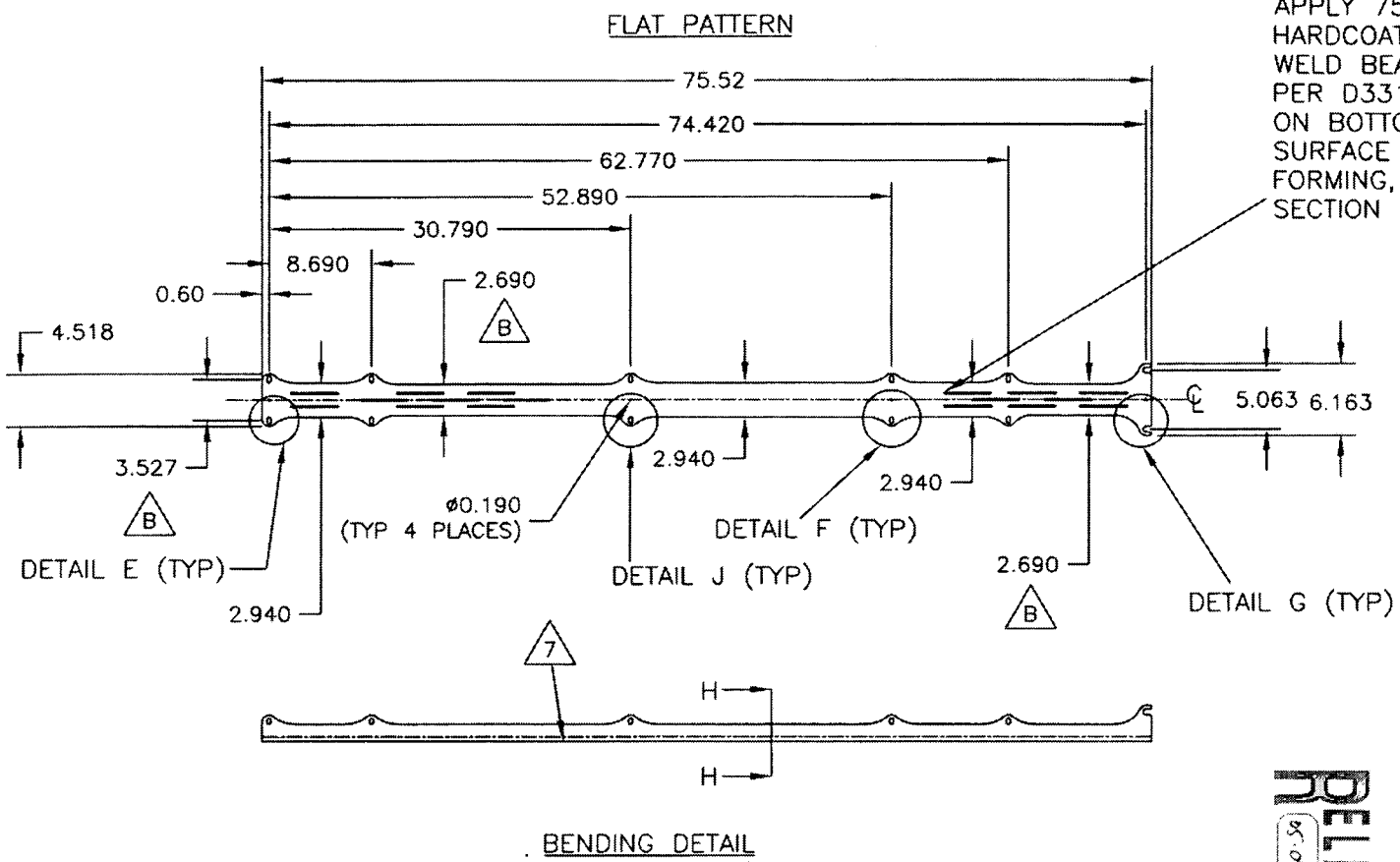
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NOTE: Date & initial all entries

77829



APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



RELEASED
05.01.30

DESIGN	APPROVED	DRAWING NO.	REVISION
DATE	05.06.06	D3319	SHEET 2 OF 5
TITLE	WEARPLATE	SCALE	1:15

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

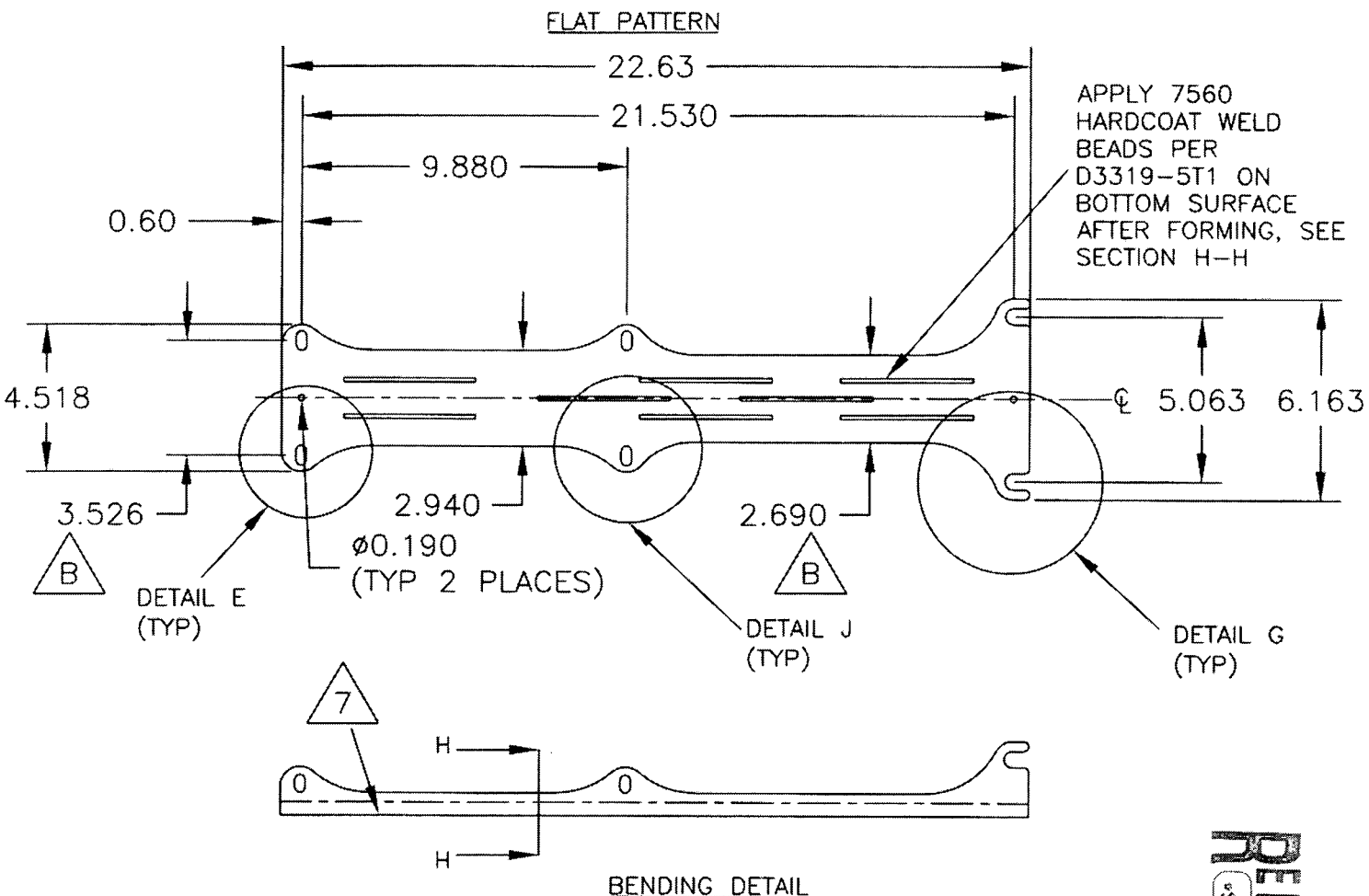
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77029



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-07-30

DESIGN	D31	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	WEARPLATE
		DRAWING NO.	D3319
		SHEET	3 OF 5
		SCALE	1:5

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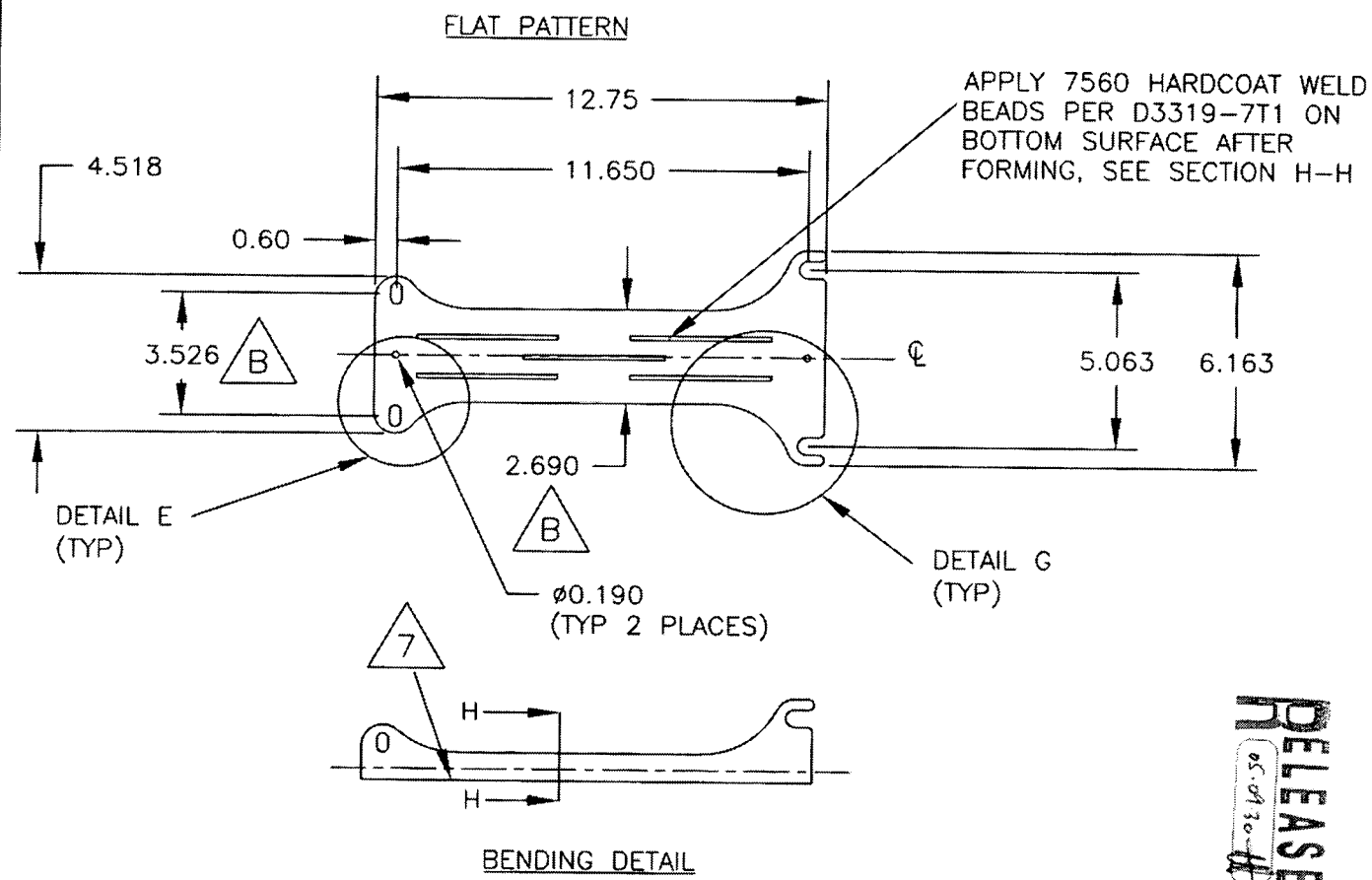
NOTE: Date & initial all entries

77029



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
				SHEET 4 OF 5
				SCALE
				1:5

RELEASED
05.07.30-41



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

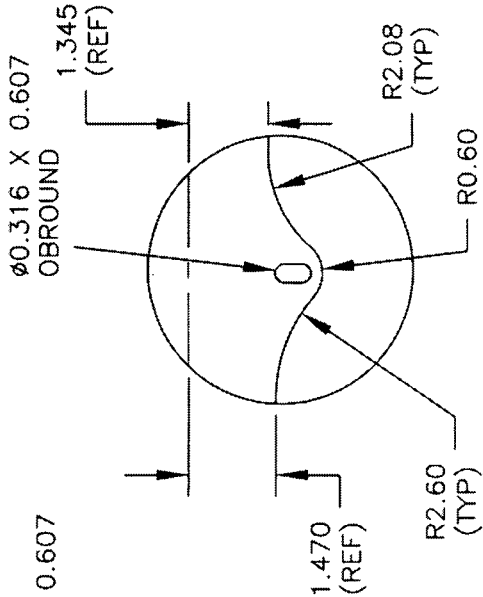
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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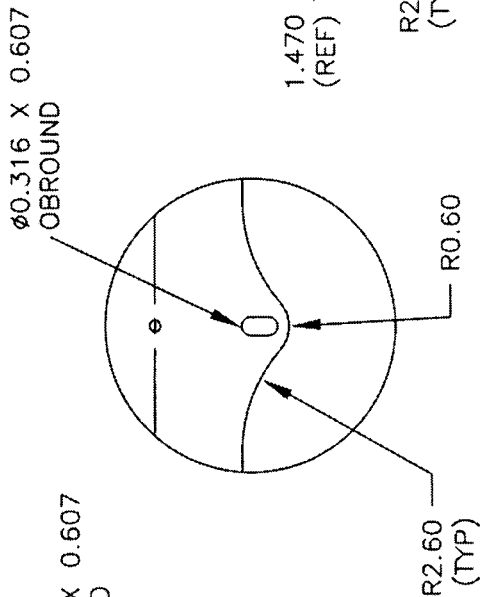
NOTE: Date & initial all entries



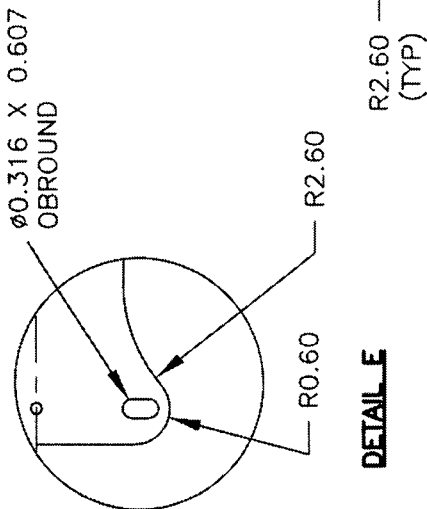
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3



DETAIL J

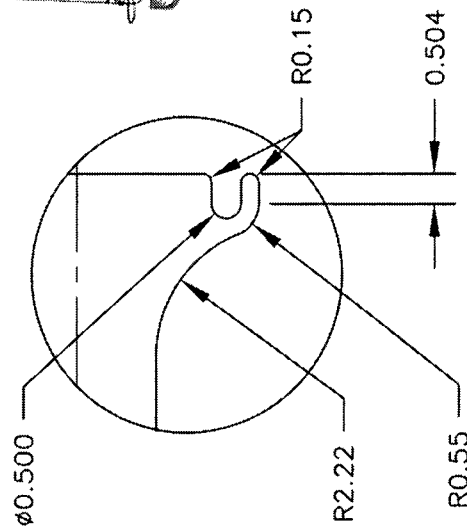


DETAIL F

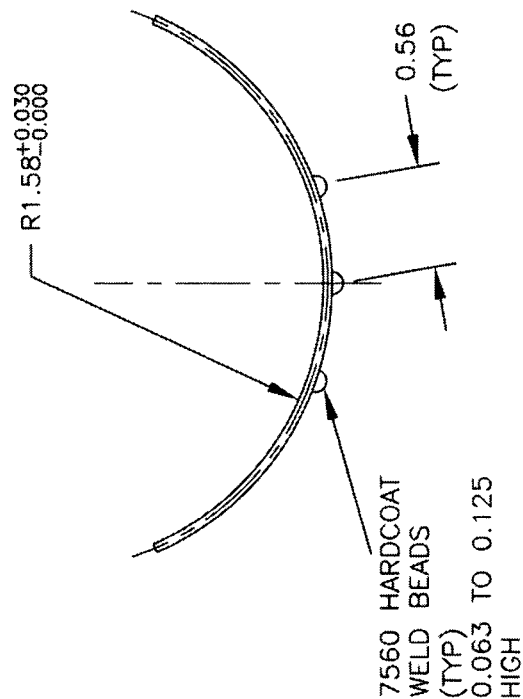


DETAIL E

RELEASED
05 09 30



DETAIL G



**SECTION H-H
(SCALE 1:1)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries